

Date: Tuesday, 8/21/2007 1:59:18 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services
 Job Number : 34122
 Estimate Number : 10908
 P.O. Number : N/A
 This Issue : 8/21/2007 S.O. No. : N/A
 Prsh Rev. : NC
 First Issue : N/A
 Previous Run : 30961
 Written By :
 Checked & Approved By :
 Comment : Est. A 05.01.13 New issue KJ/JLM
 Est Rev:B Now on Waterjet 06-09-25 JLM
 est C 07.05.14 rev C dwg EC

Drawing Name : PANEL
 Part Number : D33307
 Drawing Number : D3330 REV C
 Project Number : N/A
 Drawing Revision : C
 Material : N/A
 Due Date : 9/20/2007 Qty: 10 Um:

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	M1010S125	1010-1025 sheet .125
		Comment: Qty.: 0.7971 sf(s)/Unit Total : 7.9710 sf(s) 1010-1025 sheet .125. Batch: M1010S125
2.0	WATER JET	FLOW WATER JET
		Comment: FLOW WATER JET 1-Cut as per Dwg D3330 Dwg Rev: C Prog Rev: C 2-Deburr if necessary → 1B07-09-13
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
		Comment: INSPECT PARTS AS THEY COME OFF MACHINE
4.0	QC8	SECOND CHECK
		Comment: SECOND CHECK
5.0	BRAKE NC	NC BRAKE
		Comment: NC BRAKE Deburr Form as per Dwg D3330 1B07-09-13

W/O:

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA:  Date: 07/07/24
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 8/21/2007 1:59:18 PM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: PANEL

Job Number: 34122

Part Number: D33307

Job Number:



Seq. #: Machine Or Operation:

Description :

6.0 QC5

INSPECT WORK TO CURRENT STEP



cont'd

Comment: INSPECT WORK TO CURRENT STEP

7.0 PACKAGING 1

PACKAGING RESOURCE #1



(c)

Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: WA16

PCL 02-09-24

(10)

8.0 QC21

FINAL INSPECTION/W/O RELEASE



(D)

Comment: FINAL INSPECTION/W/O RELEASE

08/03/04

Job Completion



WA-09-24.

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	34122
Description: Frame Assembly	Part Number:	D3330-7
Inspection Dwg: D3330 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by:	SAD	Audited by:	S	Prototype Approval:	N/A
Date:	07/08/22	Date:	07/08/22	Date:	N/A

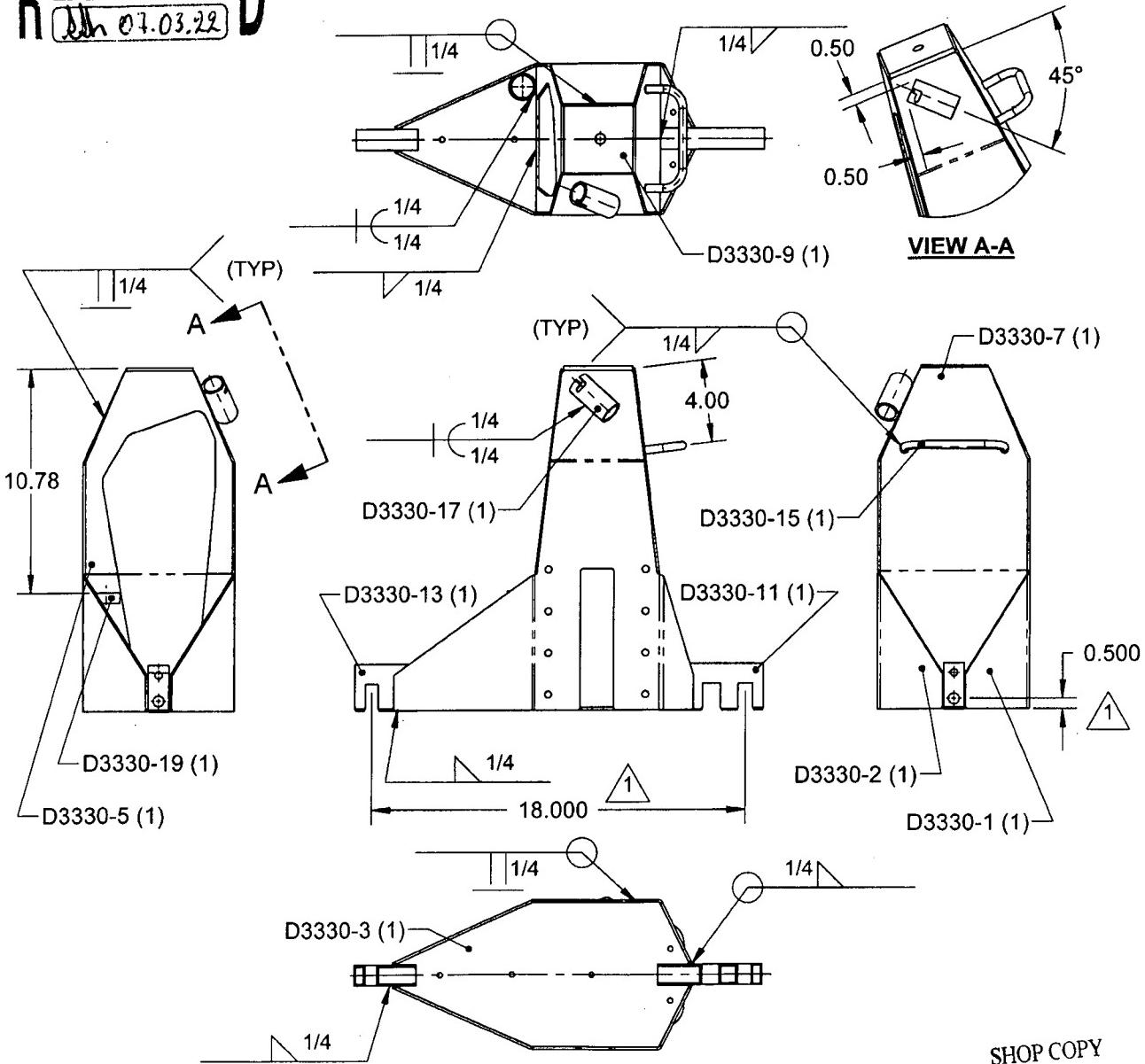
Rev	Date	Change	Revised by	Approved
A	06.10.27	New Issue	KJ/JLM	
B	07.05.16	Dwg Rev updated	KJ/EC	Z

DART

DESIGN <i>CB</i>	DRAWN BY <i>CB</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED <i>MM</i>	APPROVED <i>MM</i>	DRAWING NO. D3330
DATE 07.03.20		REV. C SHEET 1 OF 9 SCALE 1:8

RELEASED
MM 07.03.22

REV	DATE	DESCRIPTION
A	04.12.16	NEW ISSUE
B	05.02.26	RE-DESIGN
C	07.03.20	ADD 0.100 DIM; RAISED BEND OF -1/2 BY 0.125

**D3330-041 FRAME WELDMENT****NOTES:**

1) POSITION PARTS AS PER JIG D3330-041T1

2) WELD PER QSI 004

3) FINISH: POWDER COAT PAINT FIRE RED (4.3.5.10) PER DART QSI 005 4.3

4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

5) ALL DIMENSIONS ARE IN INCHES

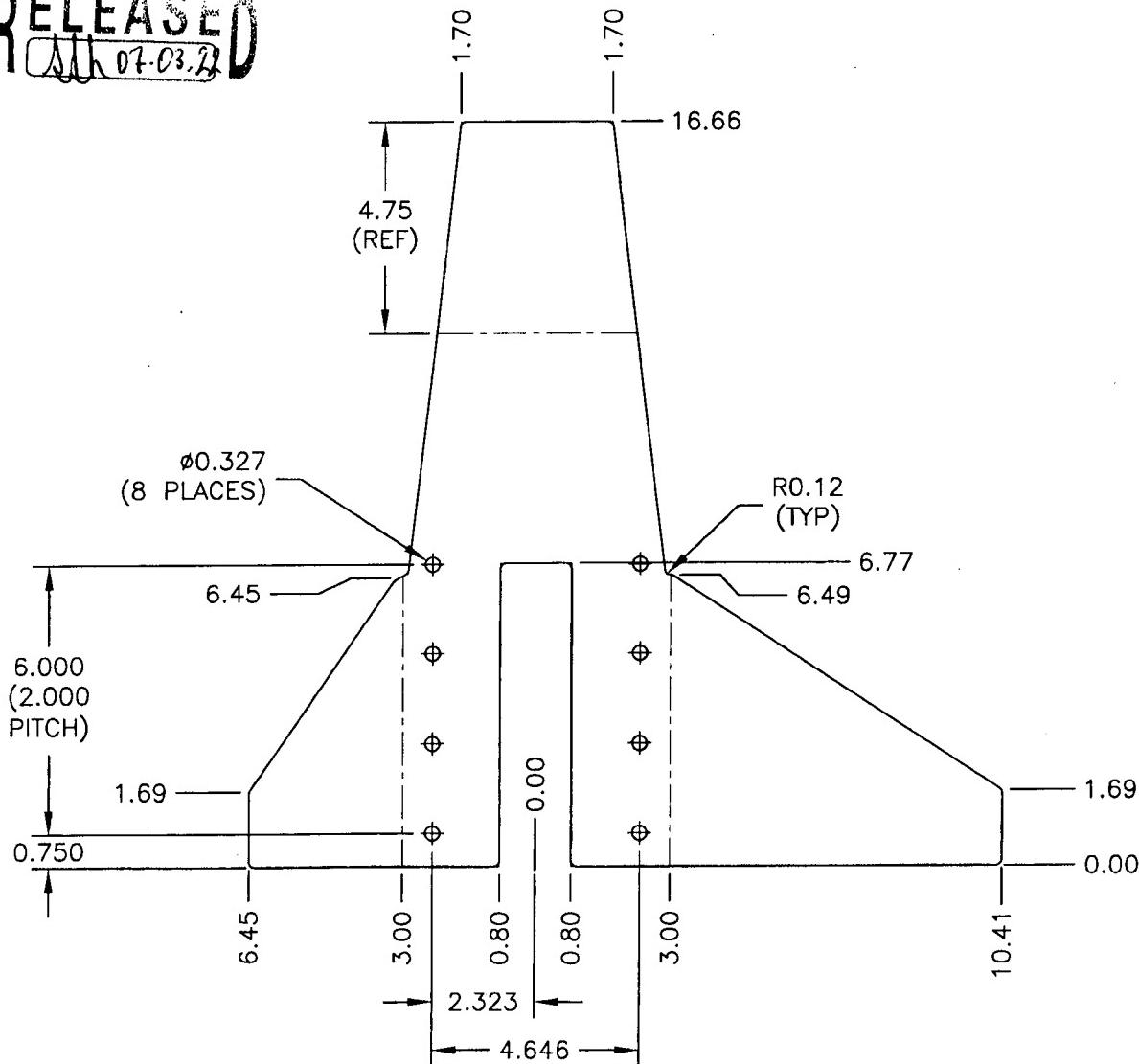
6) BREAK ALL SHARP EDGES 0.010 TO 0.020

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DATE 07.03.20	TITLE FRAME WELDMENT		SCALE 1:4

RELEASED



D3330-1 PANEL

NOTES:

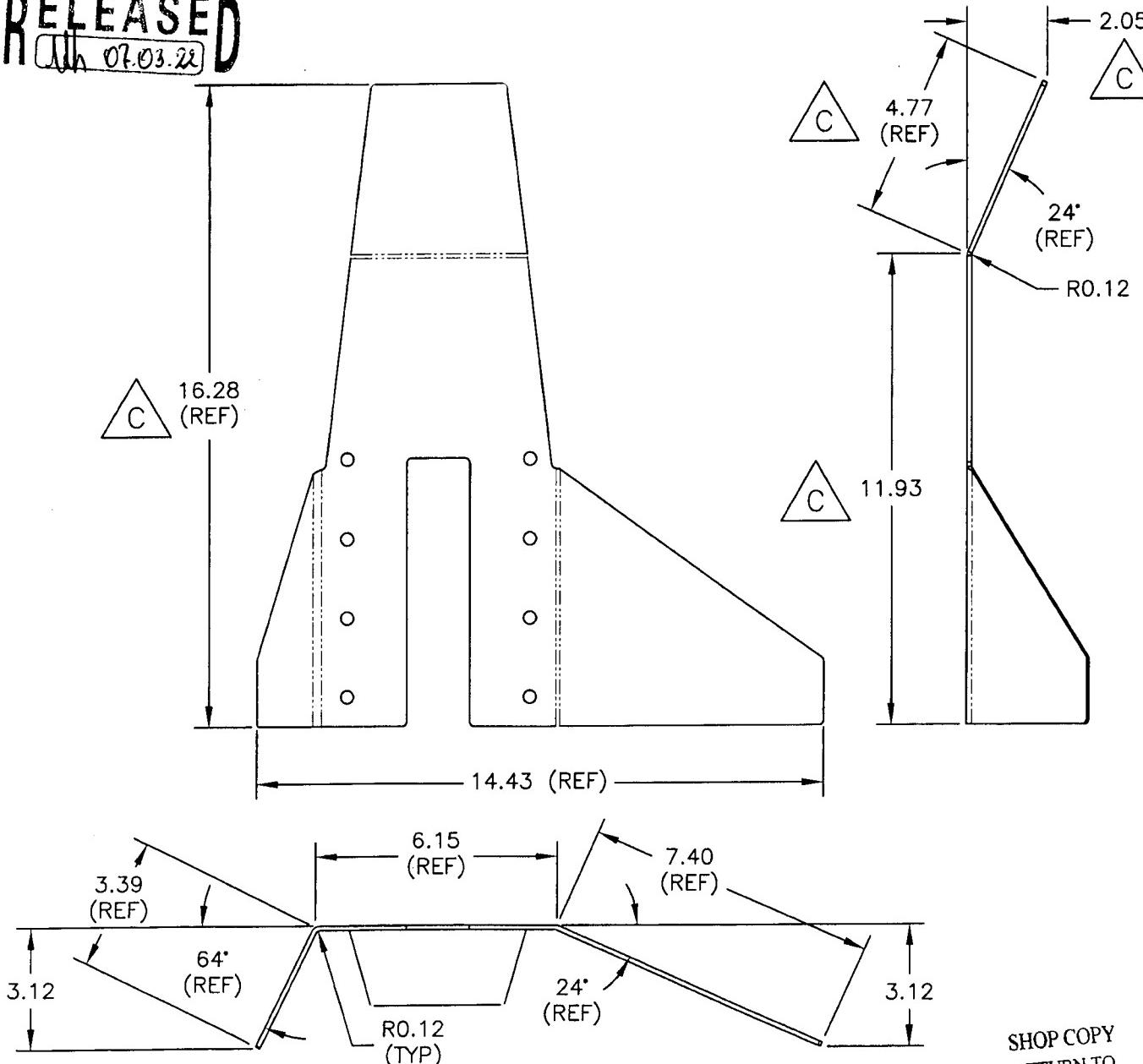
- NOTE:

 - 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA C
38W/44W/50W/60W/70W SERIES STEEL 11 GAUGE (0.125")
 - 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 3) ALL DIMENSIONS ARE INCHES
 - 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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07.03.20		D3330	SHEET 3 OF 9

TITLE
FRAME WELDMENTSCALE
1:4**RELEASED**
07.03.20

D3330-1 BEND DETAIL (SHOWN)
BEND D3330-2 (OPPOSITE)

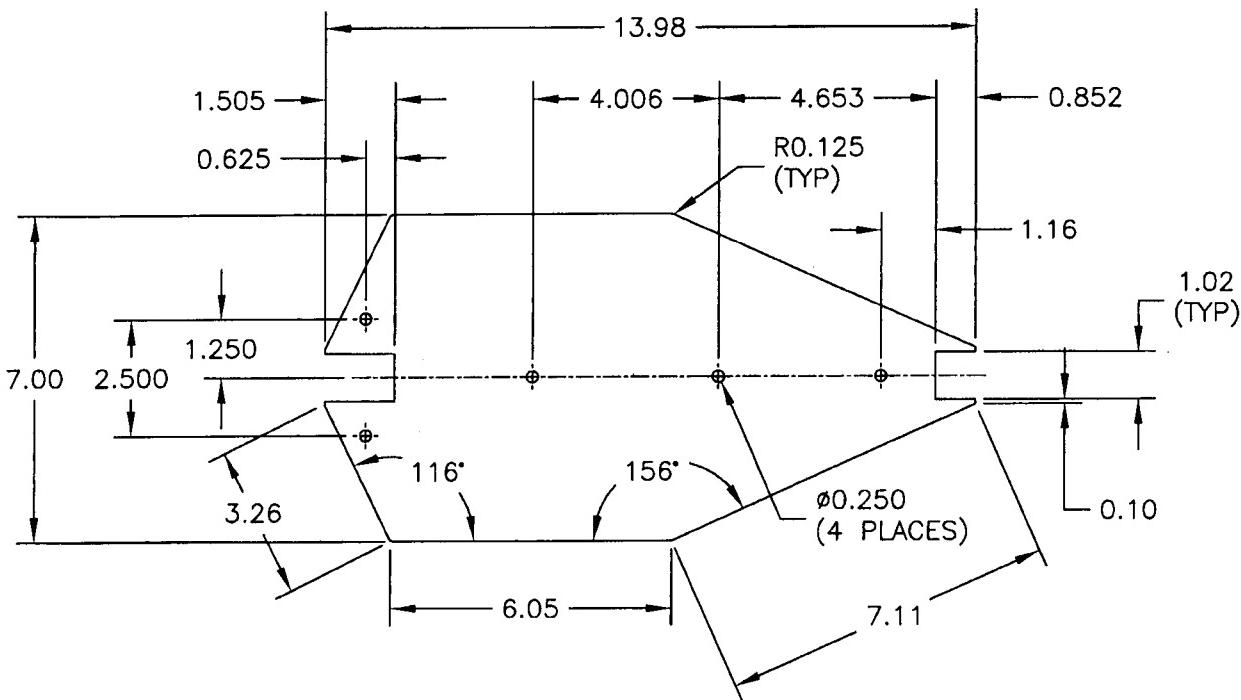
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DATE 07.03.20		TITLE FRAME WELDMENT	SCALE 1:4

RELEASED
07.03.20D3330-3 PLATE

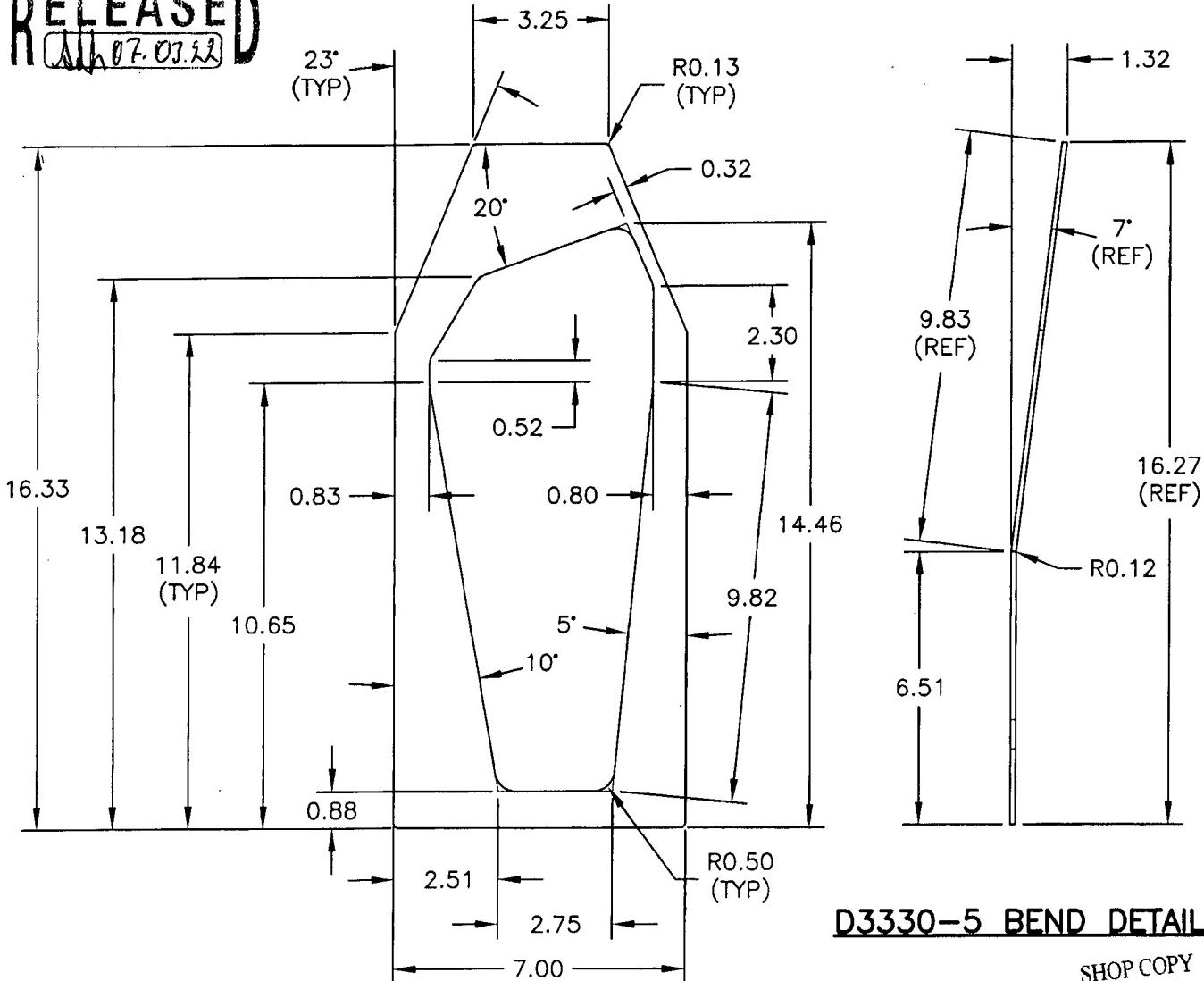
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NOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21,
38W/44W/50W/60W/70W SERIES STEEL 11 GAUGE (0.125 THICK)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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RELEASED
07.03.22**D3330-5 BEND DETAIL**

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NOTES:

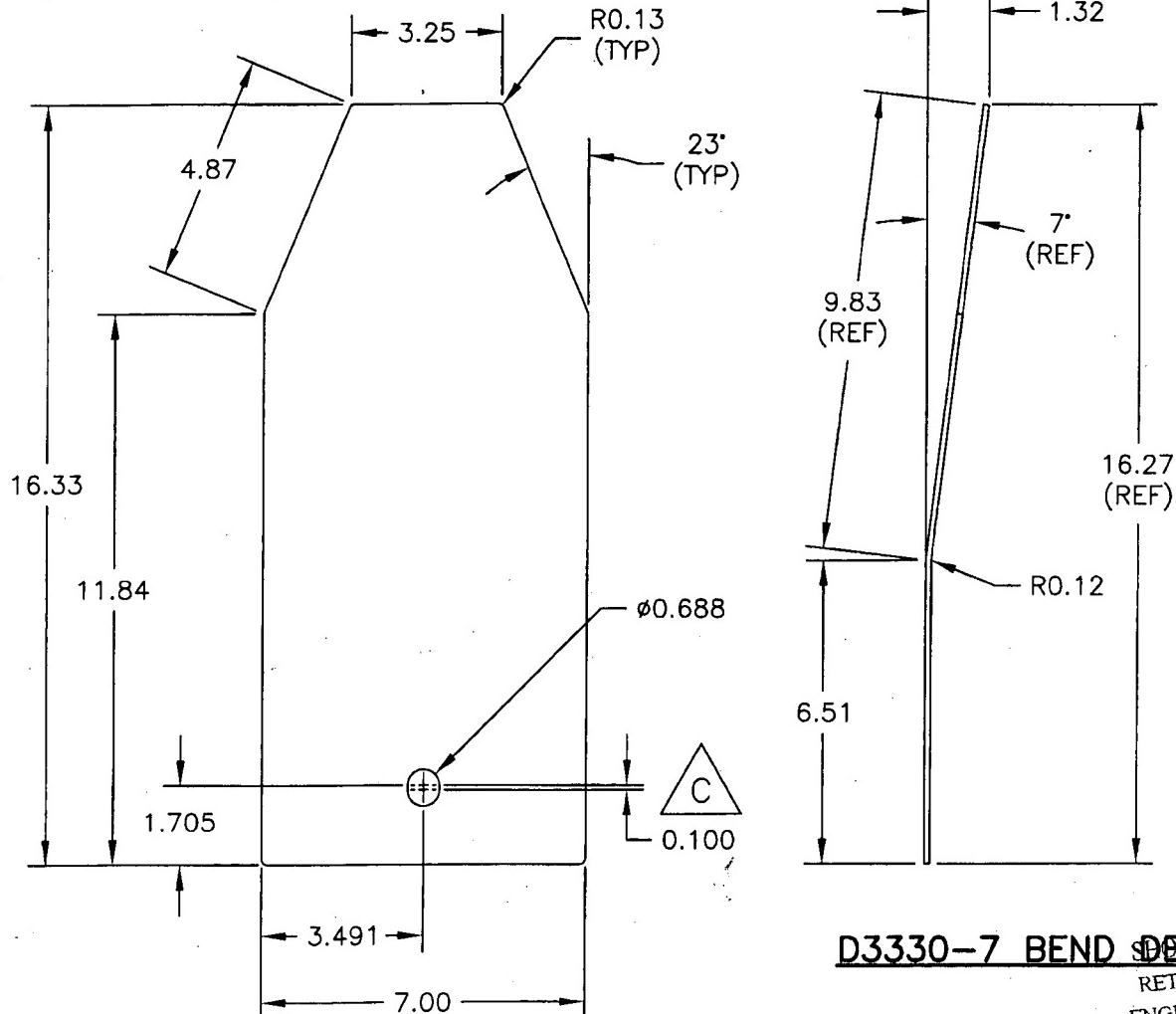
- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21,
38W/44W/50W/60W/70W SERIES STEEL 11 GAUGE (0.125 THICK)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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DATE	07.03.20	D3330	SHEET 6 OF 9

SCALE

1:4

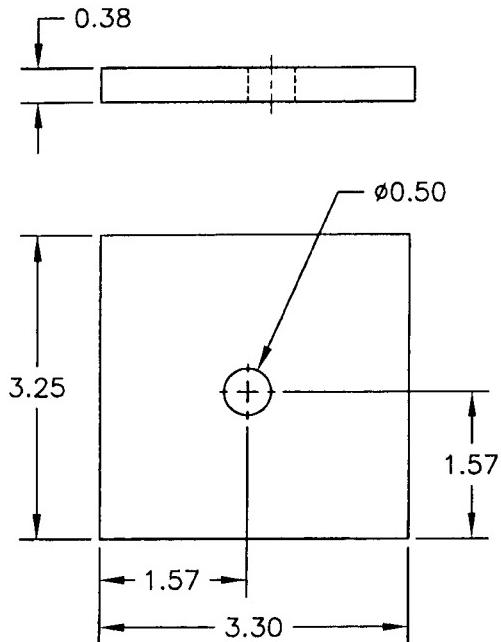
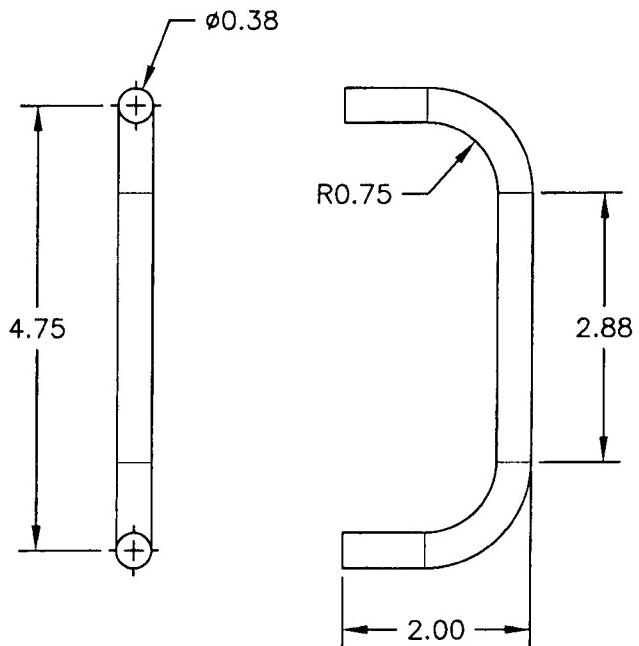
RELEASED
07.03.12**FLAT PATTERN****NOTES:**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008 OR CSA G40-21,
38W/44W/50W/60W/70W SERIES STEEL 11 GAUGE (0.125 THICK)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

D3330-7 BEND DETAIL
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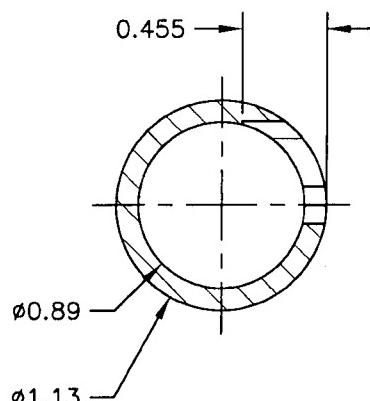
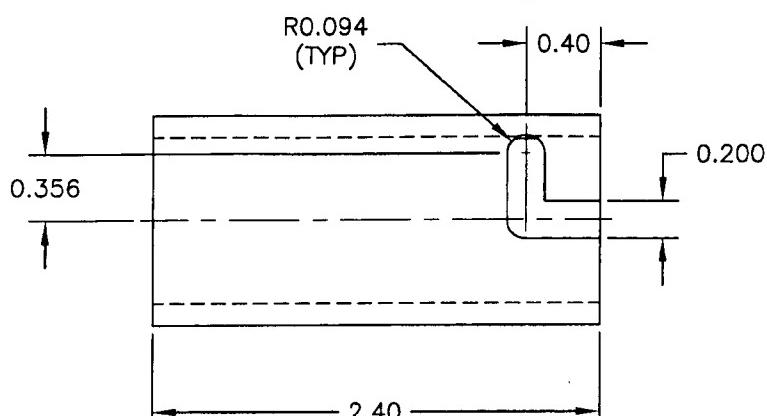
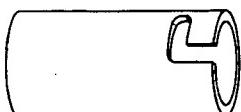
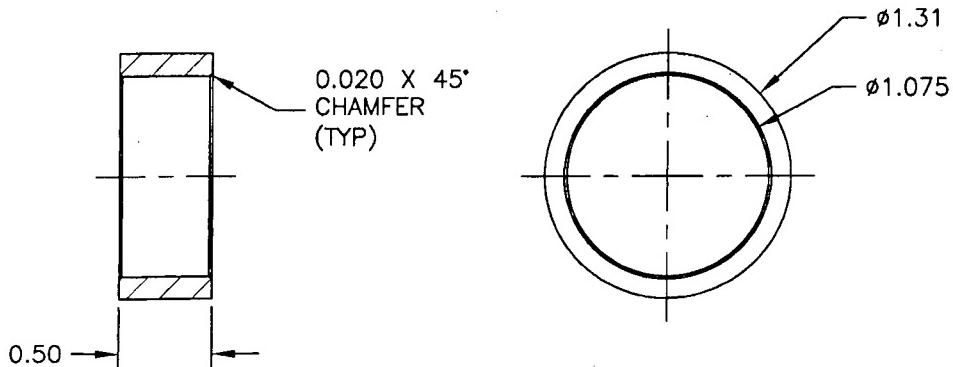
RELEASED
07.03.22△ D3330-9 TOP PLATE△ D3330-15 HANDLENOTES:

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A1008, 0.375 STEEL
(REF. DART SPEC. M1010-B0.375x3.500)
- 2) MATERIAL: AISI 1018-1025 ROUND BAR PER MIL-S-7097
(REF. DART SPEC. M1018-R0.375)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010

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DATE		D3330	SHEET 8 OF 9
07.03.20		TITLE	SCALE
		FRAME WELDMENT	1:1

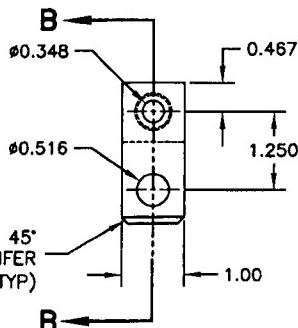
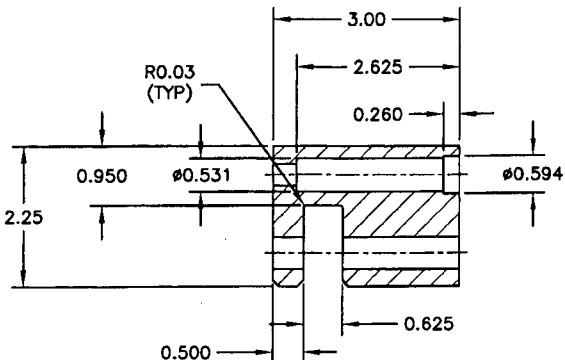
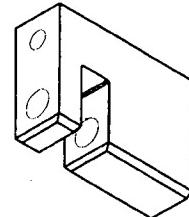
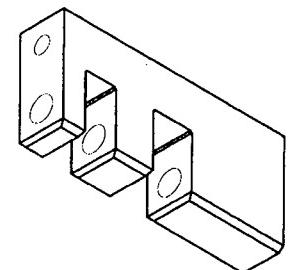
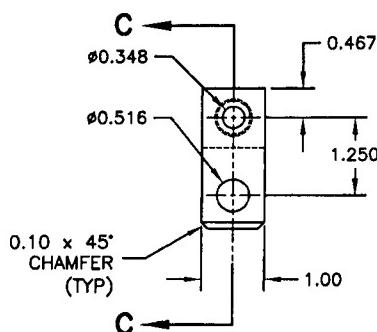
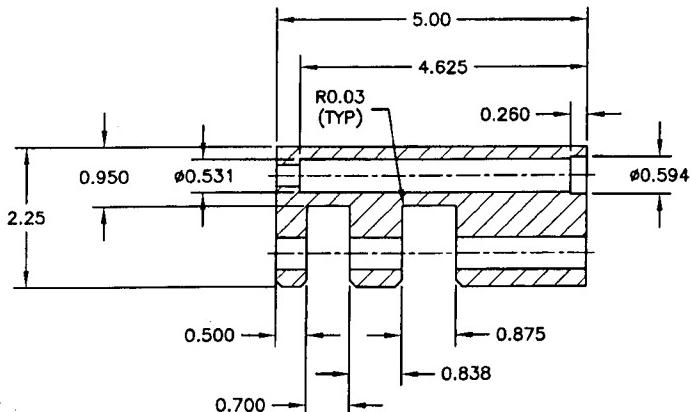
A
ASECTION A-AD3330-17 HANDLE SOCKETD3330-19 HANDLE RIMNOTES:

- 1) MATERIAL: 1010-1025 ROUND BAR STEEL PER MILL-S-7097
(REF. DART SPEC. M1025TR)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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		REV. C SHEET 9 OF 9 SCALE 1:3

**RELEASED**
07.03.21**SECTION B-B****D3330-13 SHORT PIN BRACKET****SECTION C-C****D3330-11 LONG PIN BRACKET****NOTES:**

- 1) MATERIAL: AISI 1010-1025 OR ASTM A36/A366/A569/A570, 1.000 THICK (REF. DART SPEC. M1010-B1.000x02.250)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
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